

# Work Order ID 56311

February 17, 2010 2:33:57 PM



Page 1

Item ID: D3204-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal

Start Date: 2/17/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *M*

Date: 10-2-17

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3204	Rev A1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.000" x 0.375" x 3.100" long Bar

*MVF*  
10/02/18

*6* *0*

*F10*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA357 and Dwg D3204-2- Deburr Identify as D3204-9

*MVF*  
*DJP*  
10/02/22

*6* *2*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*DJP*  
10/02/22

*6*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3204-9 PAR #: (1) 2 Fault Category: Machined Parts NCR: Yes No DQA: [Signature] Date: 10/03/04  
 Resolution: Scrap / Accepted Disposition: Scrap / USE AS IS QA: N/C Closed [Signature] Date: 10/03/04

NCR: <u>56311</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/18	110	First part scrap during opp#2 R.C. creates error while During <del>stop</del> setup R.C. Lack of Attention.	<u>[Signature]</u> 10/02/18	Adjusted "X" and "Y" Origenes Scrap and replace Bld# <u>19059</u>	<u>MMWZ</u> 10/02/18	<u>[Signature]</u> 10/03/04	<u>[Signature]</u> 10/03/04	<u>[Signature]</u> 10/03/04
10/02/22	110	Scrap part because part was not tight enough in vise and moved .025" in "X" axe R.C. COA.	<u>CP</u> 10.02.22 per QSI 042	Scrap and Replace Bld# <u>19059</u> Acceptable, MINOR EFFECT ON POSITION	10/02/22 <u>DTP</u>	<u>G</u> 10/02/22	<u>CP</u> 10.02.22 per QSI 042	<u>G</u> 10/03/04

NOTE: Date & initial all entries

# Work Order ID 56311

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Page 2

Item ID: D3204-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal

Start Date: 2/17/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

*S.F. 10/02/22*

*8 0*

Memo

0.00

140



Packaging

Packaging

Identify as per dwg & Stock Location: *CAL*

0.00

Memo

0.00

*10/02/22*

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/03/03*

*02 03/01/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 17, 2010 2:34:01 PM

Page 1

Work Order ID: 56311



Parent Item: D3204-9



Parent Item Name: Pedal

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP: ☐ C005.08.11 ☐ Added Step 25 ☐ KJ/JLM ☐

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X02.00 0		Purchased	No			100	f	6.8000	1.6977			



6061-T6 Bar .375 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

19059

6.8

6.8

2.264(f)

DJP  
10/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	5634
<b>Description:</b> Pedal		<b>Part Number:</b>	D3204-9
<b>Inspection Dwg:</b> D3204 <b>Rev:</b> A1			<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	0.50	✓			
0.250	+/-0.010	0.251	✓			
0.080	+/-0.010	0.079	✓			
0.110 x 45°	+/-0.010	0.110 x 45°	✓			
0.620	+/-0.010	0.620	✓			
3.000	+/-0.010	3.002	✓			
2.00	+/-0.030	1.998	✓			
0.310	+0.010/-0.000	0.312	✓			
0.780	+/-0.010	0.784	✓			
1.750	+/-0.010	1.753	✓			
Ø0.134	+0.005/-0.000	0.138	✓			

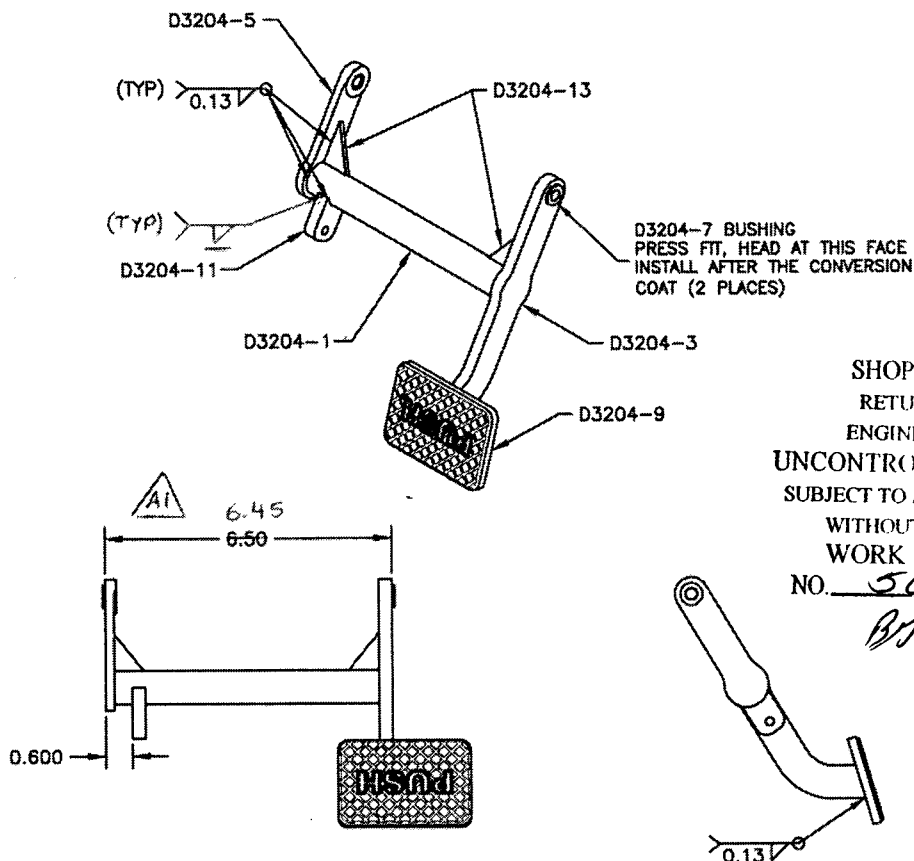
<b>Measured by:</b> DJP	<b>Audited by:</b> S.B.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/02/22	<b>Date:</b> 10/02/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	



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CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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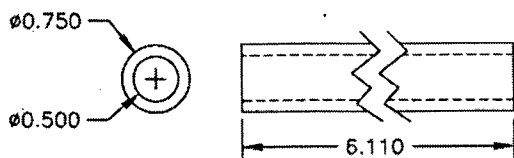
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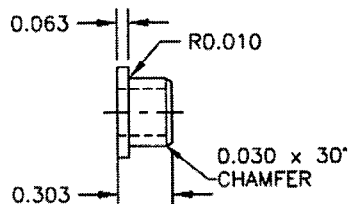


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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

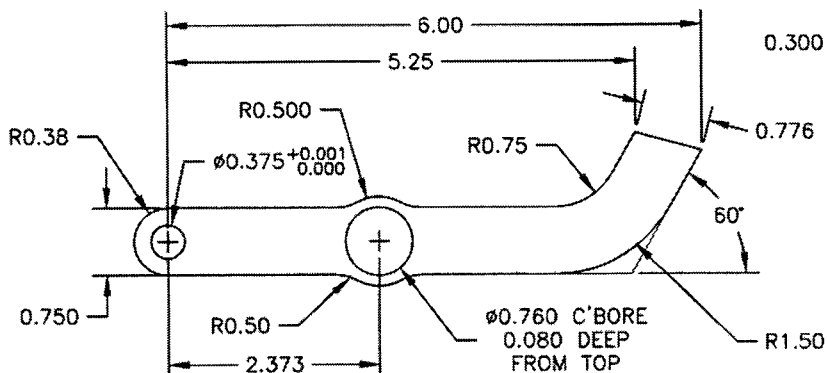
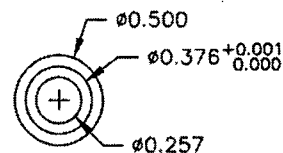
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04.04.05



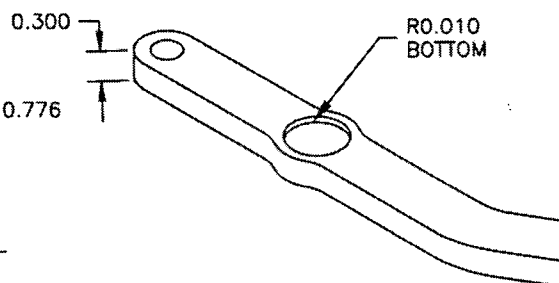
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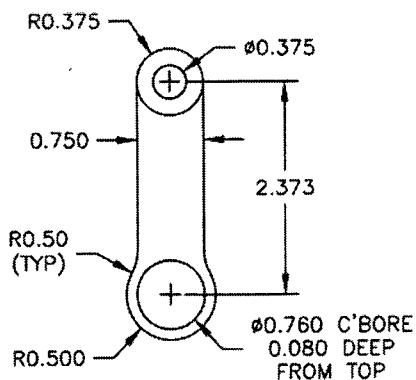
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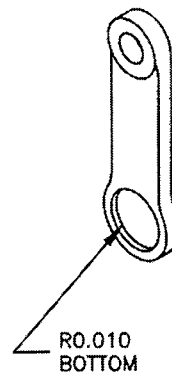
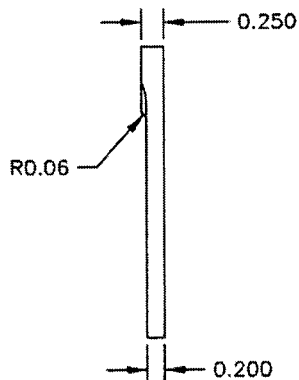
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SCALE 1:2



w/0 56311



3 D3204-5 ARM  
SCALE 1:2



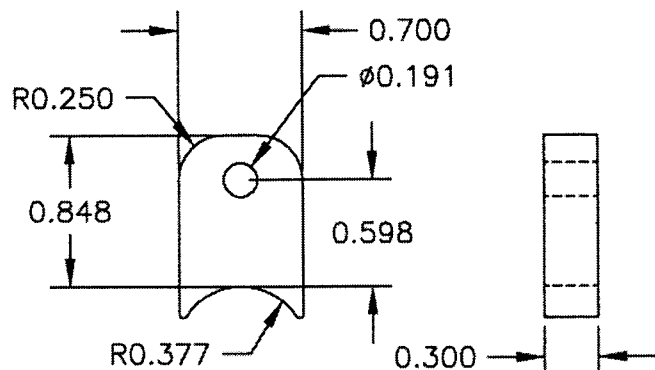
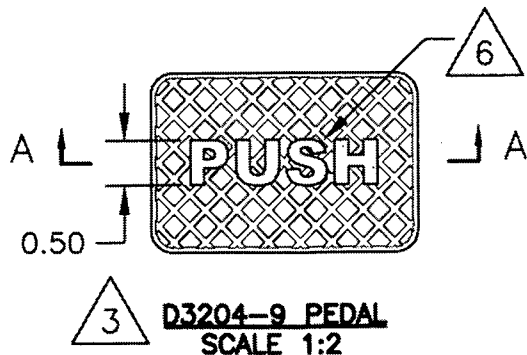
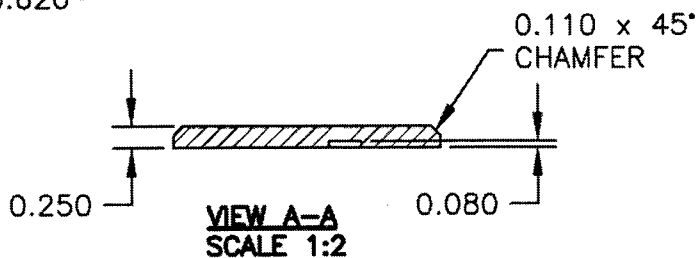
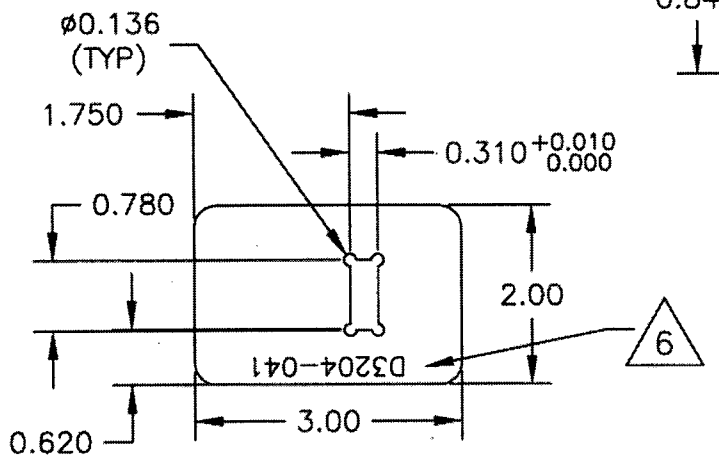
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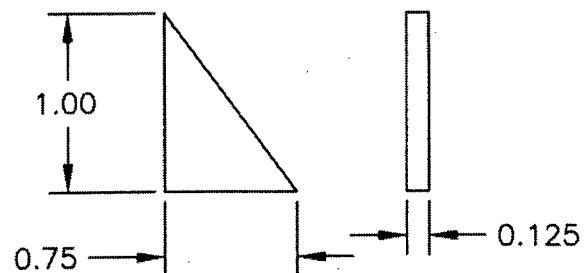
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D3204-11 PLATE  
SCALE 1:1

w/o 56311



D3204-13 GUSSET  
SCALE 1:1

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